

Date: Tuesday, 10/06/2008 8:52:01 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 39743		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 10/06/2008 S.O. No. :	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 37931	Material	:
Written By	:	Due Date	: 17/06/2008 Qty: 13 Um: Each
Checked & Approved By	: <u>JUD 08.6.10</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total : 19.1783 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)Identify as D3211-1
 Batch: 108 415 B 8-8-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3211
 Dwg Rev: A1
 Prog Rev: A1

B 8-8-11

(B)

2-Deburr if necessary B 8-8-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-8-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/11 x13

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

Done at step # 2.8

S 6/8/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 8:52:01 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39743

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



~~P10~~

Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 08/09/19 (13)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/02 (13)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M- 08/04/22

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320
9:30

M- 08/09/24

(13X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-24

(X13)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2H

8/9/24

(X13)

SC

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

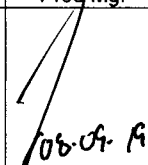

08/09/25

Job Completion





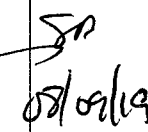
MF 08-09-25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-09-19	6.0	used 3/16 radius die, 1/8 is too sharp a radius.	SP	08/09/19	13		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/19	6			TOOK Die 3/16 into Die 1/8 	SP 08/09/19 			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39743
Description: Bracket		Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-8-11	Date: 08/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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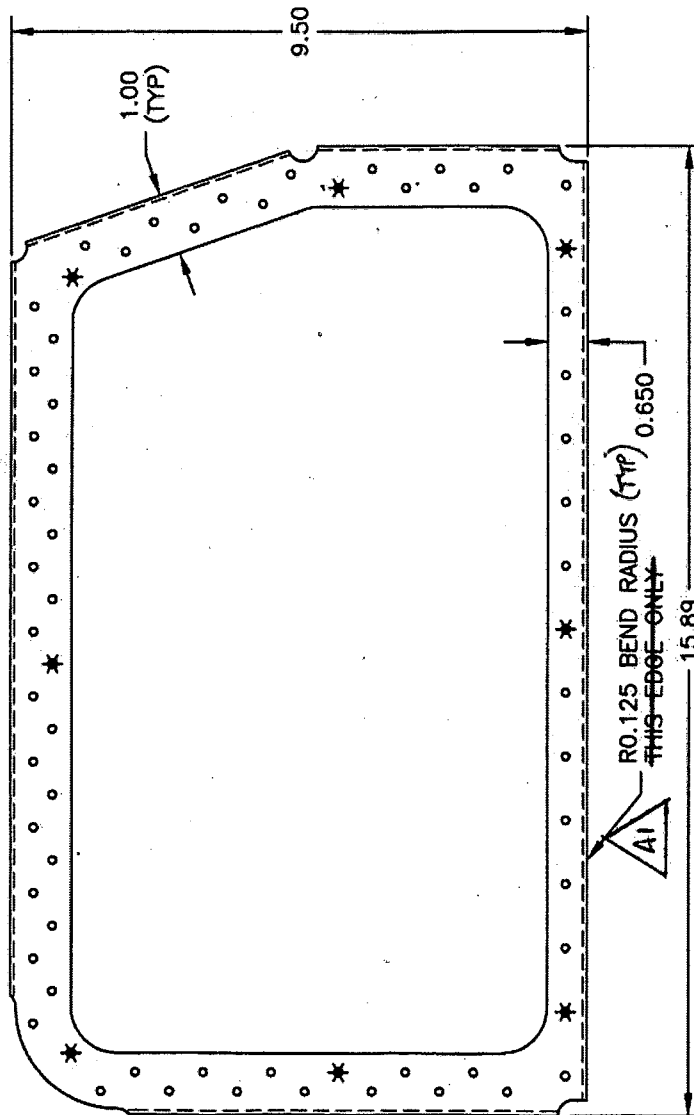
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL BEND RADIUS TO R0.125	

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"
CHECK PER TEMPLATE D3211-1T1
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF ~~0.188~~ **0.125** EXCEPT WHERE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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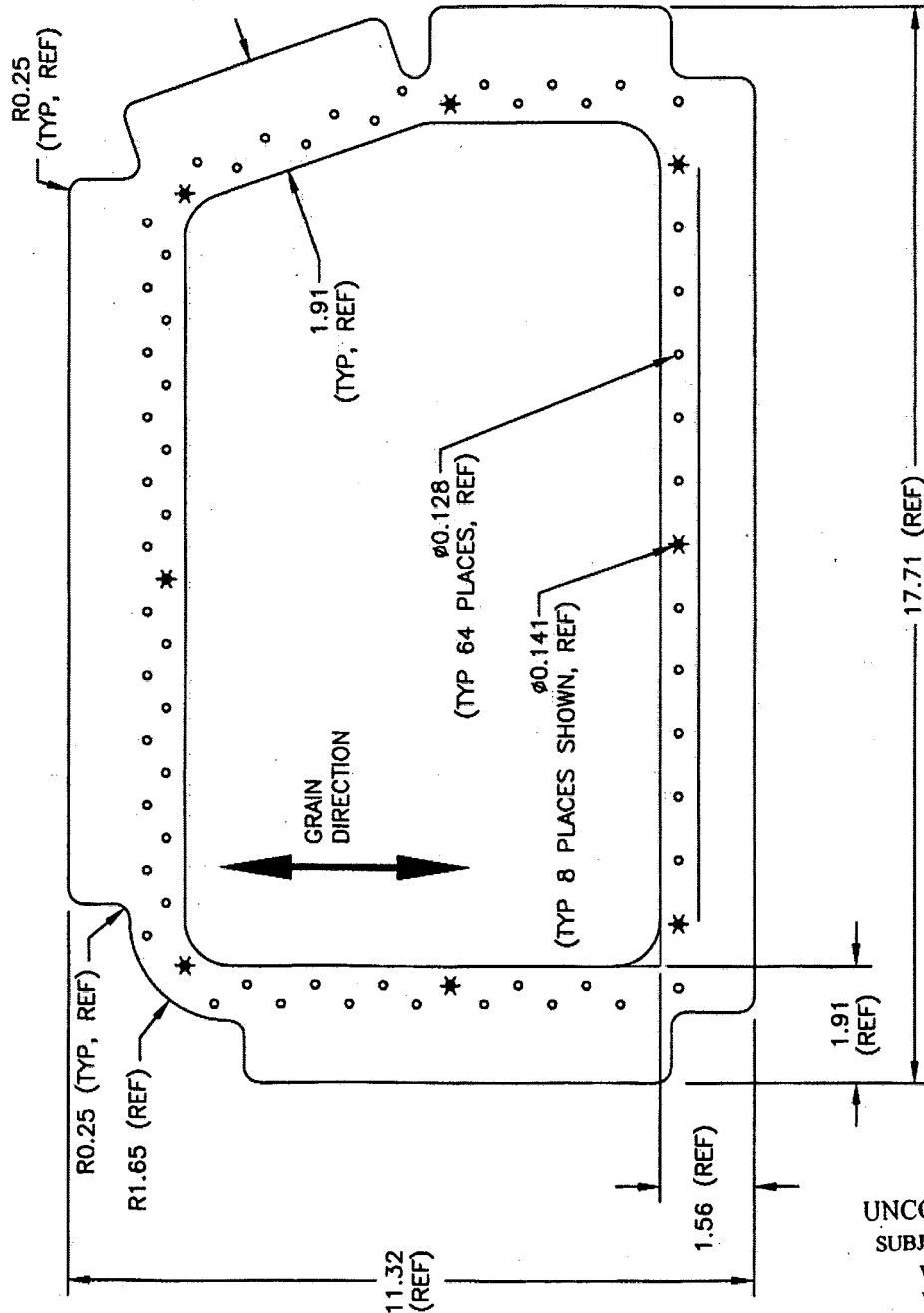
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03	TITLE BRACKET		SCALE 1:3

RELEASED
03.09.15

D3211-1 FLAT PATTERN



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Dart Aerospace Ltd

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